

Date: Thursday, 3/1/2007 11:34:17 AM
User: Kim Johnston

Process Sheet

SPLIT-

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 30998
Estimate Number : 11745
P.O. Number : N/A
This Issue : 3/1/2007 S.O. No. : N/A
Prsht Rev. : NC
First Issue : N/A Type : MACHINED PARTS
Previous Run : 30907
Written By : 07.03.01
Checked & Approved By : 07.03.01
Comment : Est Rev: A New Issue 06-01-06 JLM

Drawing Name : LUG ASSEMBLY

Part Number : D3394043
Drawing Number : D3394 REV A
Project Number : N/A
Drawing Revision : A
Material : N/A
Due Date : 12/3/2007

Qty: 50 Unit: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 D2423 Lug Extrusion



Comment: Qty.: 0.0735 f(s)/Unit Total: 14.7000 f(s)

D2423 Lug Extrusion

Batch: 30062

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut Blank to .850"

3.0 OUTSIDE SERVICE OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Send Blanks To: Metec/Mast Precision Machining

P/O: BLKT 00001

Machine D3394-3 as per Dwg D3394

C 267103108 (200) 50

4.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

5.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

07/06/12 (50)
07/06/13 (50)
completed

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Drawing Name: LUG ASSEMBLY

Job Number: 30998

Part Number: D3394043

Job Number:

Seq. #:

Machine Or Operation:

Description:

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

07-06-14

50

7.0

POWDER COATING

POWDER COATING

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

07-06-15

4034

8.0

INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

MS3548993

GROMMET

Comment: Qty.: 2.0000 Each(s)/Unit Total: 400.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 MS35489-93 Grommet

M103688

UMF

07-06-25

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3394

UMF

07-06-25

11.0

QC5

INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP

12.0

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

13.0

QC21

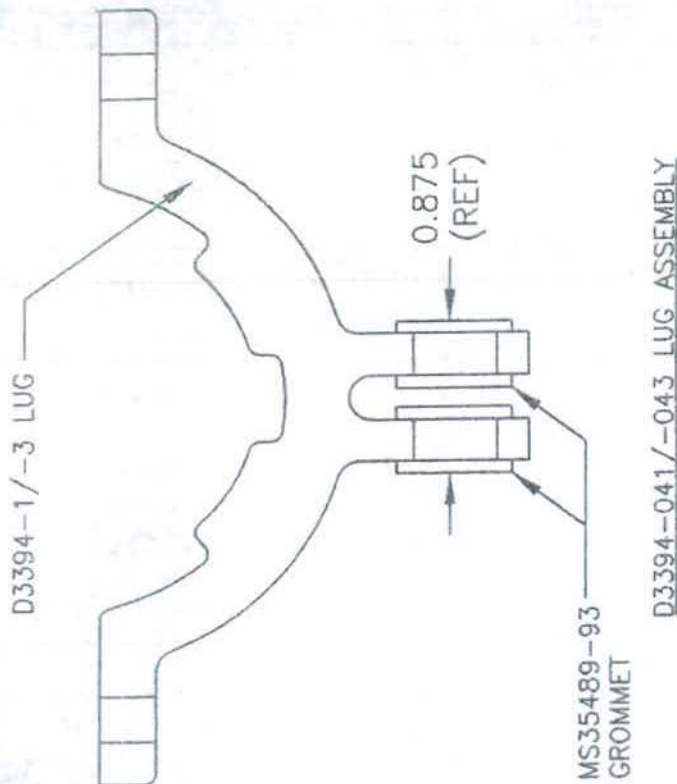
FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED AH	APPROVED AH	DRAWING NO. D3394	REV. A SHEET 1 OF 3
DATE 05.02.14		TITLE LUG	SCALE 1:1
A	05.02.14	NEW ISSUE	

**PARTS LIST FOR D3394-041/-043 LUG ASSEMBLY**

QTY -		PART NUMBER	DESCRIPTION
041	043		
X		D3394-041	LUG ASSEMBLY
	X	D3394-043	LUG ASSEMBLY
1		D3394-1	LUG
	1	D3394-3	LUG
2	2	MS35489-93	GROMMET

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WITHOUT NOTICE
WORK ORDER
NO. 30998

RELEASED

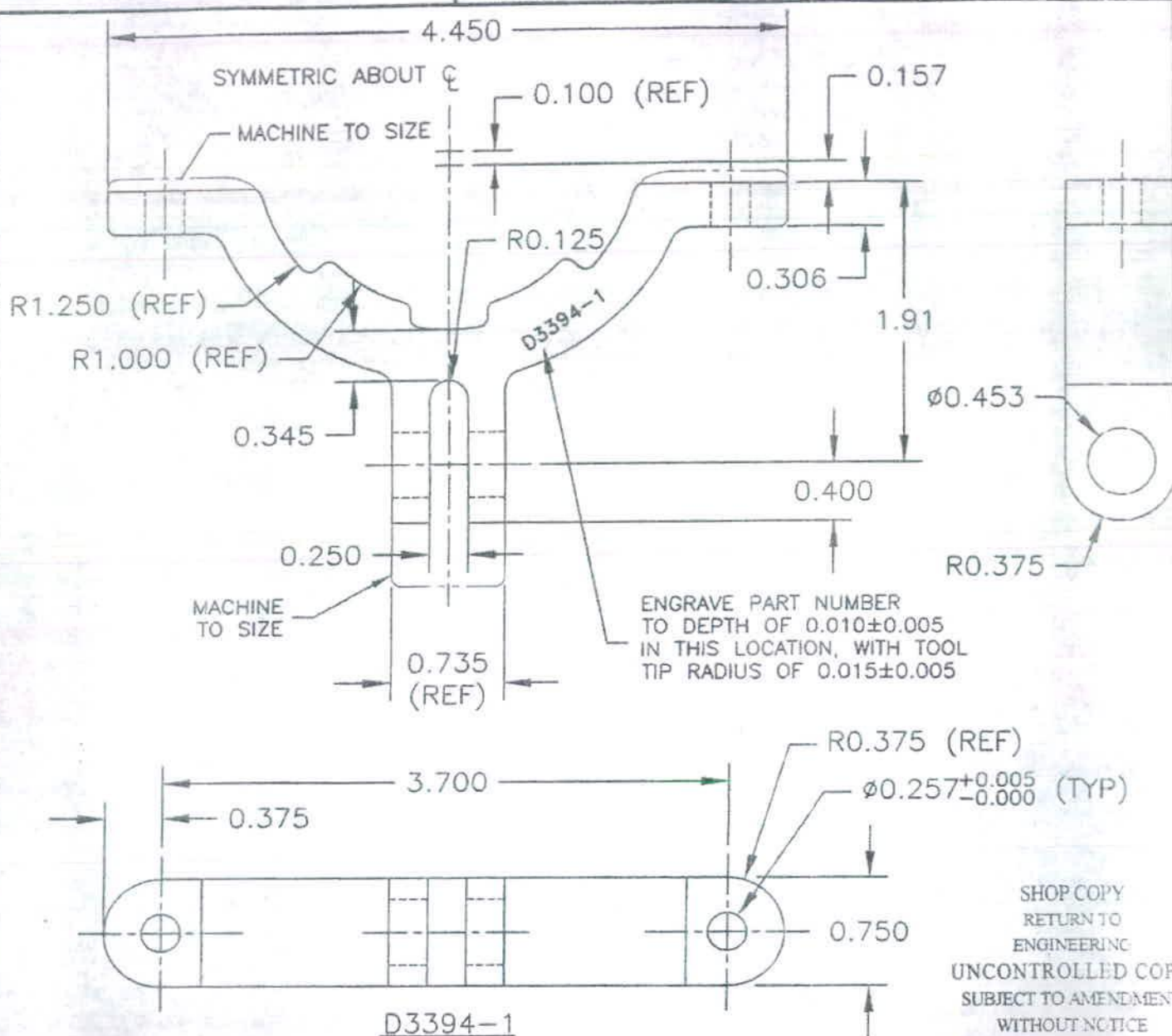
05.11.14

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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3394	REV. A SHEET 2 OF 3
DATE 05.02.14		TITLE LUG	SCALE 1:1

**D3394-1 NOTES**

- 1) MAKE FROM EXTRUSION D2423
- 2) BREAK ALL EDGES 0.000-0.015
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER
NO. 30998

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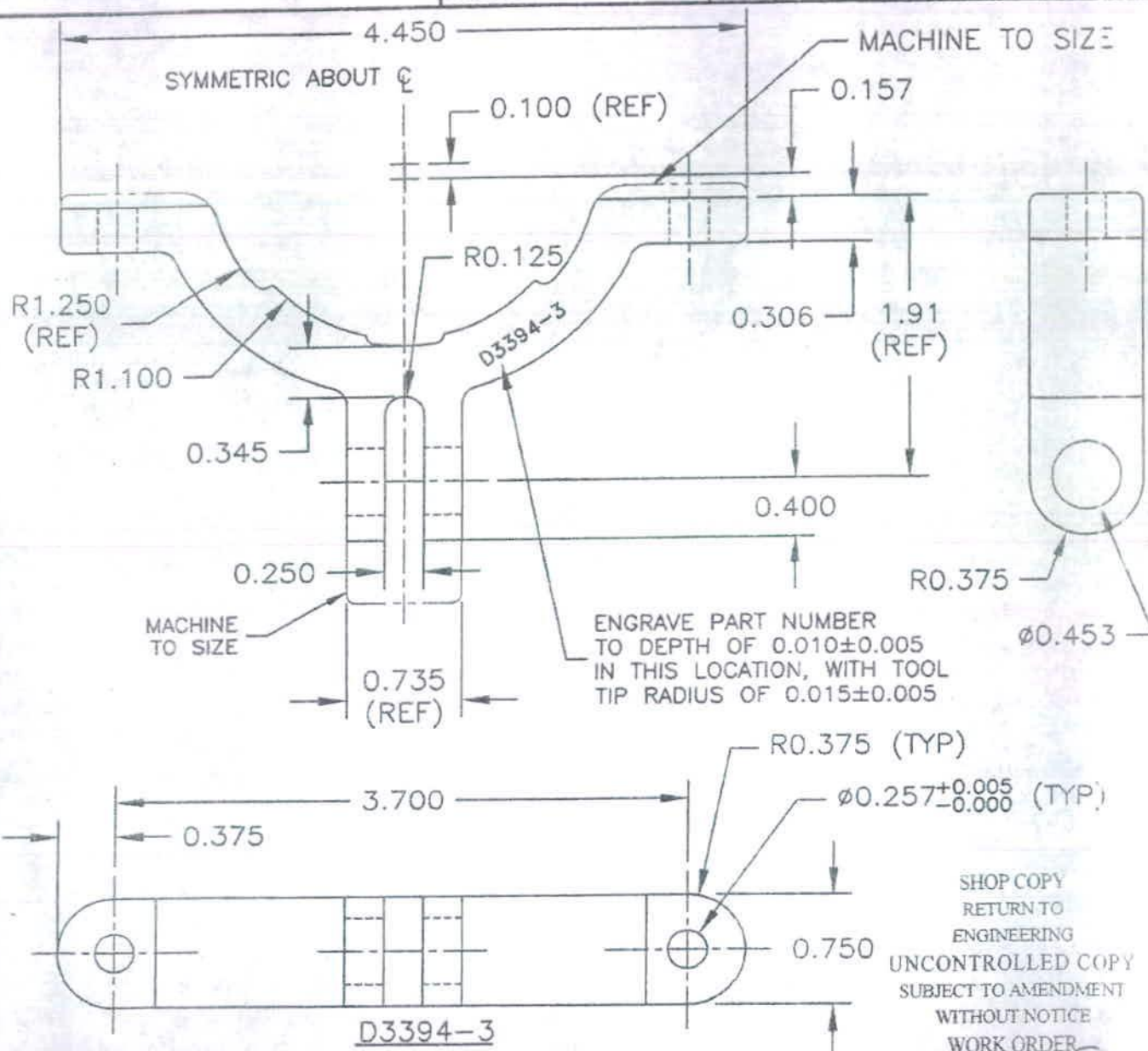
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3394	REV. A SHEET 3 OF 3
DATE 05.02.14	TITLE LUG	SCALE 1:1	

**D3394-3 NOTES**

- 1) MAKE FROM EXTRUSION D2423
- 2) BREAK ALL EDGES 0.000-0.015
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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NO. 30998

RELEASED

05-11-14

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CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

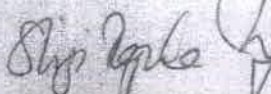
same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
30	D2230-3	Lug B30993	BLKT00001
50	D2731-3	Lug B30994	BLKT00001
50	D2731-7	Lug B30995	BLKT00001
150	D3235-1	Lug B30996	BLKT00001
50	D3394-1	Lug B30997	BLKT00001
50	D3394-3	Lug B30998	BLKT00001

MATERIAL: supplied by DART D2423 B30062

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi (Regula) Walz

Vankleek Hill, June 12, 2007

